

Date: Thursday, 05/02/2009 3:29:21 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT ENGINE MOUNT KIT	
Job Number :	45521	Part Number :	D205770011	
Estimate Number :	13253	Drawing Number :	IIN205-770 REV A	
P.O. Number :		Project Number :	N/A	
This Issue :	05/02/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	44427	Material :		
Written By :		Due Date :	10/02/2009	Qty: 1 Um: Each
Checked & Approved By :	JUD 09.02.09			
Comment :	Est Rev:A new issue ECN1165p 08-03-31 DD verified by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



JUD 09/02/09



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

J 09/02/10

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D3684043

MOUNT ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

MOUNT ASSEMBLY

batch: 45522

J 09/02/10 (X)

4.0

D3684045

INBOARD LEG ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

LEG ASSEMBLY

batch: 345523

J 09/02/10 (X)

5.0

D36921

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch: 44689

J 09/02/09 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:29:21 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT ENGINE MOUNT KIT

Job Number: 45521

Part Number: D205770011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolts

batch: M110155

SS 09/02/09 (X)

7.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 110023

SS 09/02/09 (X)

8.0

D3685041

BIPOD MOUNT ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BIPOD MOUNT ASSEMBLY

batch: B45525

SS 09/02/10 (X)

9.0

D3686041

MONOPOD ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MONOPOD ASSEMBLY

batch: B45527

SS 09/02/10 (X)

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sorbelio @

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-770-011 CHG001

Location:

PPP Rev:

Draft

SS 09/02/10 (X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/10

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	107.8 in	1574 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	2.74 m	18.1 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

SHOP COPY
 RETURN TO
 PARTS
 UNIFORMED COPY
 ELEMENT
 NO. 45521

